

Date: Wednesday, 3/12/2008 1:41:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB		
Job Number	: 37848		Part Number	: D21741		
Estimate Number	: 10195		Drawing Number	: D2174-1 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 3/12/2008	S.O. No. :	Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SMALL /MED FAB			
Previous Run	: 31689		Due Date	: 3/31/2008	Qty:	10
Written By	:		Um:	Each		
Checked & Approved By	: <u>HB 08 03 12</u>					
Comment	: Est C 04-06-09 Reformat KJ/RF Est Rev:D As per Rev E 06-11-22 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
		Comment: Qty.: 0.4958 sf(s)/Unit Total : 4.9581 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Batch: <u>106223</u> <u>HB</u> <u>8-3-19</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2174 Dwg Rev: <u>E</u> <u>HB</u> <u>8-3-19</u> Prog Rev: <u>E</u>
		2-Deburr if necessary <u>HB</u> <u>8-3-19</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB</u> <u>8-3-19</u>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack
		<u>1/4 Done at step 22</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



5/08/09 (10)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8/1 08-03-23 (10)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

5/08/09 (10)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

P. Min 8/3/09 (10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

100803/05

Job Completion



u 08.03.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37848
Description: Web	Part Number:	D2174-1
Inspection Dwg: D2174	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:		Prototype Approval:	N/A
Date:	8-31-9	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN
RF

CHECKED
PH

APPROVED
CH

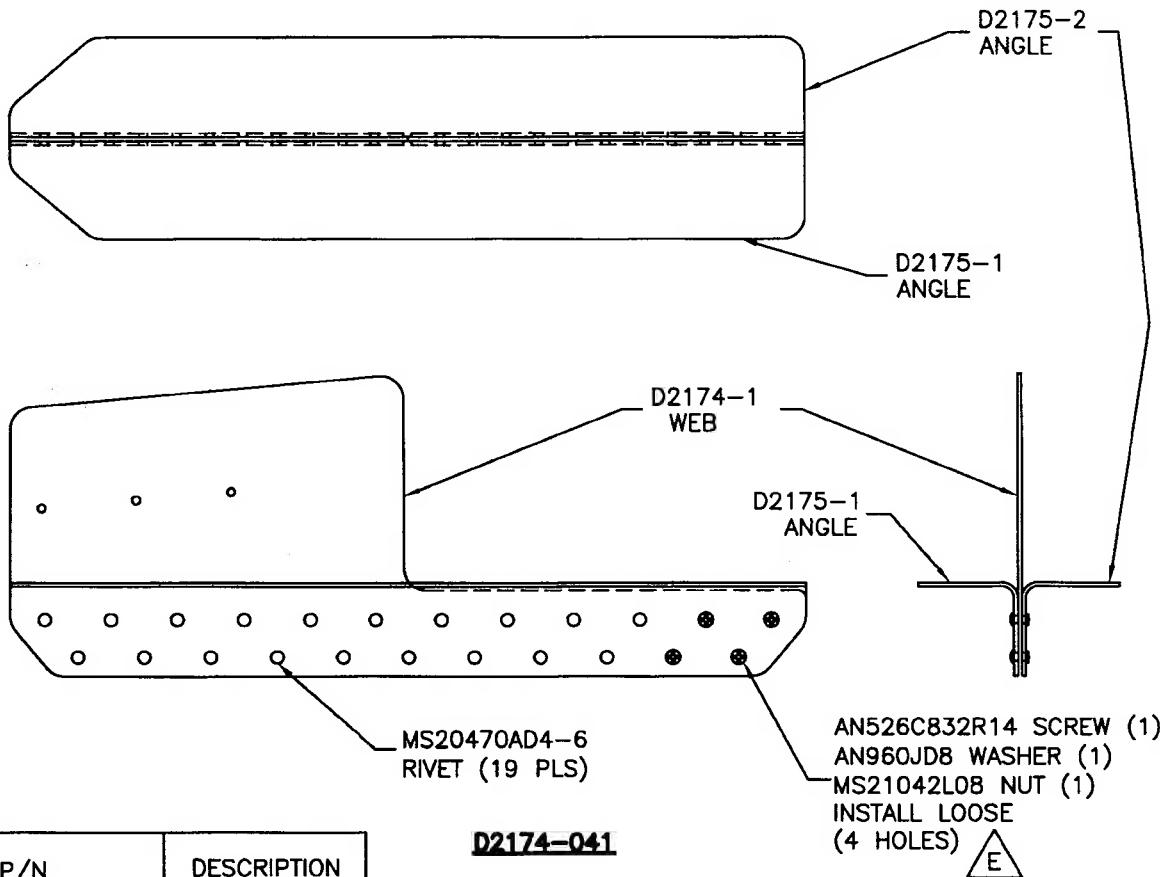
DRAWING NO.
D2174

DATE
06.09.25

TITLE
WEB ASSEMBLY

REV. E
SHEET 1 OF 2

SCALE
1:3



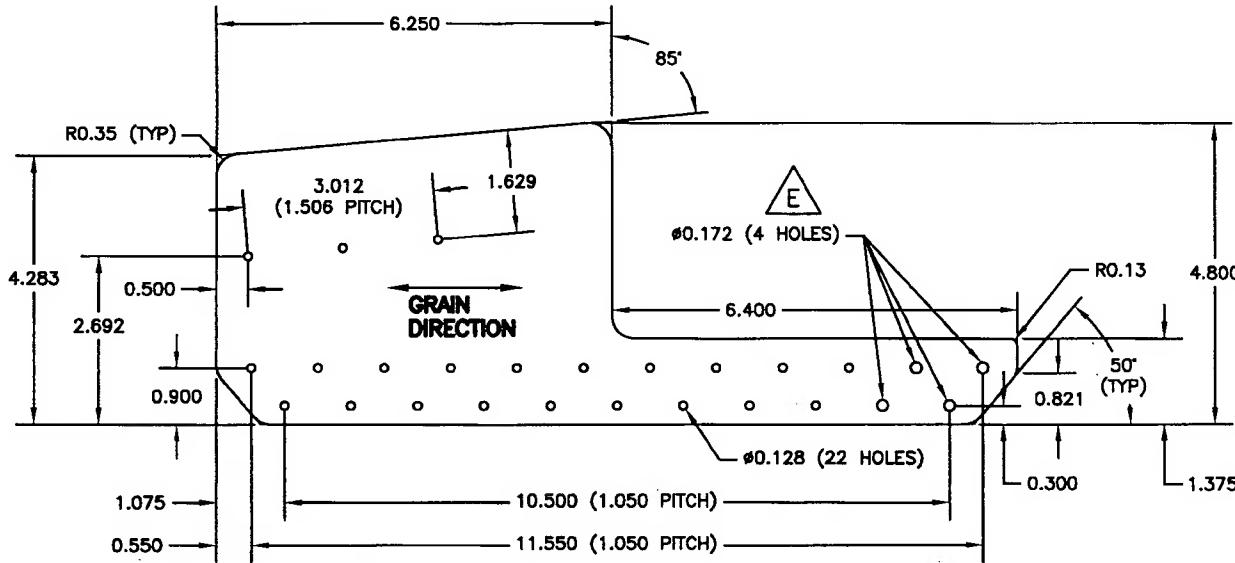
QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDERED
NO. *31848*

RELEASED
06.10.13

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

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ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32848

DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2174
DATE 06.09.25	TITLE WEB	REV. E SHEET 2 OF 2 SCALE 1:3

RELEASED
06 16 3
4

DART

